

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013551**Date Inspected:** 28-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

| | | | |
|------------------------------------|----------------|----|-----|
| CWI Name: | Li Lin, Tu Jun | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | |
|----------------------------------|-----|--------|
| CWI Present: | Yes | No |
| Rod Oven in Use: | Yes | No N/A |
| Weld Procedures Followed: | Yes | No N/A |
| Verified Joint Fit-up: | Yes | No N/A |
| Approved WPS: | Yes | No N/A |
| Delayed / Cancelled: | Yes | No N/A |

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10, North Tower Lift 4, AE Corner Backfill Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL4-3C/L-40, 101

NSTL4-3F/L-32, 100

NSTL4-3G/L-29, 98

NSTL4-3I/L-31, 96

NSTL4-3J/L-28, 97

NSTL4-3K/L-31, 97

NSTL4-3H/L-30, 131

Bay 10, Tower Lift 3 Strut Facade

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This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SD1-SFSA4-29A/B-9

SD1-SFSA4-31A/B-5

SD1-SFSA4-32A/B-5

SD1-SFSA4-34A/B-5

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER GRILLAGE PLATE

SAW welding of weld joint 1A located on GTSA5-B/G.

Welder is identified as 044550. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 2A located on GTSA5-B/G.

Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SMAW welding of weld joint 1A located on ESD1-TL5-2B/F.

Welder is identified as 040690. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

GRILLAGE PLATE REPAIR (T-WR3207, Y=1650)

SMAW welding of weld joint 10A/B(Repair) located on WSD1-TL5-4B/F.

Welder is identified as 044541. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

EAST TOWER LIFT 4, FIT LUG AT SKIN E

FCAW welding of weld joint 112 located on ESTL4-2K/L.

Welder is identified as 042218. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for

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your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer